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**D4881-041**  
**Job Sheet 182659**



**Part No:** D4881-041

**Job Qty:** 2 ea

**Part Name:** 206A/B AFT Leg Assembly, LH



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** High

**Job Created:** 8/29/18

**Job Tracking No:**

**Due Date:** 8/31/18

**Created By:** Jason Leroux

**Type:** SOLD

**Description:**

**Note:** DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 2 Ea  | 8/31/18    | 8/31/18  | 0.00      | 0.00    | Start Up Small Fab-4  | DAS       | AUG 29 2018 |
| 110   | Small Fab          | 2 pcs | 8/31/18    | 8/31/18  | 0.34      | 1.43    | Small Fab-8           | 6         | SEP 04 2018 |
| 120   | QC                 | 2 pcs | 8/31/18    | 8/31/18  | 0.00      | 0.00    | QC5                   | 9-89      | 68          |
| 130   | Small Fab          | 2 pcs | 8/31/18    | 8/31/18  | 0.00      | 1.43    | Small Fab-8           |           | 9-89        |
| 140   | QC                 | 2 pcs | 8/31/18    | 8/31/18  | 0.00      | 0.00    | QC5                   |           |             |
| 180   | Packaging          | 2 pcs | 8/31/18    | 8/31/18  | 0.00      | 0.00    | Packaging3-2          | 57516     | OCT 05 2018 |
| 190   | QC21-SA            | 2 Ea  | 8/31/18    | 8/31/18  | 0.00      | 0.00    | QC21                  | 6         | OCT 05 2018 |

Part Op 110 - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 AND D4885-3. DRILL OUT EACH HOLES  
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9973 AS PER DWG.

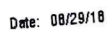
130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER DWG USE DT9974 A/R BATCH: \_\_\_\_\_ 2- LASER ENGRAVE ASSEMBLY PART#, S/N AS PER DWG QSI 44 6.8

### Job BOM

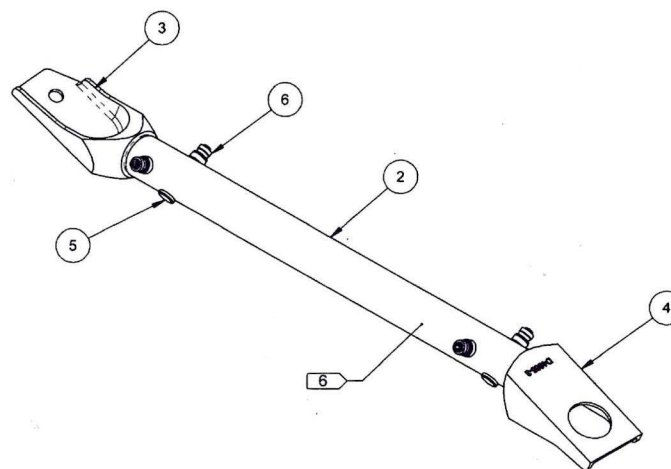
| Part / Item | Component Name | Quantity     | Operation             | Container |
|-------------|----------------|--------------|-----------------------|-----------|
| D4881-1     | Strut          | 2 Ea (1 ea)  | 90-Start up Operation | 5103372   |
| D4885-1     | End Fitting    | 2 Ea (1 ea)  | 90-Start up Operation | 5102007   |
| D4885-3     | End Fitting    | 2 Ea (1 ea)  | 90-Start up Operation | 5003356   |
| HL32PB5-12  | Hi-Lok Pin     | 8 Ea (4 ea)  | 90-Start up Operation | 5043919   |
| HL86-5      | Hi-Lok Collar  | 8 pcs (4 ea) | 90-Start up Operation | FM129022  |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | D4881-1        | 2        | 9         | 0         |
|                       | D4885-1        | 2        | 8         | 0         |
|                       | D4885-3        | 2        | 4         | 0         |
|                       | HL32PB5-12     | 8        | 83        | 0         |
|                       | HL86-5         | 8        | 83        | 0         |



| ITEM | QTY.<br>-041 | P/N        | DESCRIPTION          |
|------|--------------|------------|----------------------|
| 1    | X            | D4881-041  | AFT LEG ASSEMBLY, LH |
| 2    | 1            | D4881-1    | STRUT                |
| 3    | 1            | D4885-1    | END FITTING          |
| 4    | 1            | D4885-3    | END FITTING          |
| 5    | 4            | HL32PB5-12 | HI-LOK PIN           |
| 6    | 4            | HL86-5     | HI-LOK COLLAR        |



**D4881-041 AFT LEG ASSEMBLY, LH**  
(EQUIVALENT TO BELL P/N 206-062-103-017)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.77 lbs
- 8) ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 & D4885-3.  
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.  
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9973
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9973
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

**RELEASED**  
2014-07-07  
MND

| C          | HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 8) (ZN A8-5)                                                      | RF                                                                                                                                                                                                                                                                                       | 14.06.24     |
|------------|--------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| B          | REVISE NOTES 6), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N; REVISE SECTIONS A-A, B-B, C-C, D-D (ZN B1-2, B2-2, B1-4, B2-4) | RF                                                                                                                                                                                                                                                                                       | 14.04.08     |
| A          | NEW ISSUE                                                                                                                | RF                                                                                                                                                                                                                                                                                       | 13.09.16     |
| REV.       | DESCRIPTION                                                                                                              | BY                                                                                                                                                                                                                                                                                       | DATE         |
| DESIGN     | RF                                                                                                                       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                 |              |
| DRAWN      | RF                                                                                                                       |                                                                                                                                                                                                                                                                                          |              |
| CHECKED    | VS                                                                                                                       | DRAWING NO.                                                                                                                                                                                                                                                                              | REV. C       |
| MFG. APPR. | JLM                                                                                                                      | <b>D4881</b>                                                                                                                                                                                                                                                                             | SHEET 1 OF 5 |
| APPROVED   | HS                                                                                                                       | TITLE                                                                                                                                                                                                                                                                                    | SCALE        |
| DE APPR.   | DS                                                                                                                       | <b>LEG ASSEMBLY</b>                                                                                                                                                                                                                                                                      | NTS          |
| DATE       | 14.06.24                                                                                                                 | <small>COPYRIGHT © 2013 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

APPROVED